Work Order ID 70625

Monday, June 13, 2011 11:04:40 AM

Item ID: D900-619-011 **Accept**

Setup **Start**

Revision ID:

Item Name: Bearpaw

Stop

Start Date: 6/10/2011 **Start Qty:** 2.00

Required Date: 6/22/2011 **Req'd Qty:** 2.00

Cust Item ID:

Customer:

Reference:

Run **Start**

Approvals: **Process Plan:** ______ **Date:** 11-06-13 **Tooling:** ______ **Date:** ______

Stop

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
IIN-D900-619	A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Handwritten entries
100 / DC / Document Control	**Memo** Photocopy bluefile &type labels per PPP D900-619-011 CHG003	0.00 / 0.00	11 12 01 (2); for MLJ 11-12-1 (2)
110 / Packaging / Packaging	Pick Kit **Memo**	0.00 / 0.00	SD 11-11-30
120 / QC / Quality Control	QC4- 100% Inspect kits for completeness **Memo**	0.00 / 0.00	11 12 01 (2)

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Work Order ID 70625

Monday, June 13, 2011 11:04:40 AM

Item ID: D900-619-011 **Accept**

Setup Start / Stop

Revision ID:

Item Name: Bearpaw

Start Date: 6/10/2011 **Start Qty:** 2.00

Required Date: 6/22/2011 **Req'd Qty:** 2.00

Cust Item ID:

Customer:

Reference:

Run Start / Stop

Approvals: Process Plan: ______ Date: ______ Tooling: ______ Date: ______

QC: ______ Date: ______ SPC (Y/N): ______ Date: ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	 **Memo** Identify and pack for shipping as per PPP D900-619-011 Location:______ PPP rev: A	0.00 0.00				SP 11-12-01			
140 QC Quality Control	QC21- Final Inspection - Work Order Release **Memo**	0.00 0.00					11/12/11		

mK 11-12-01

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** _____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 11:04:46 AM

Work Order ID: 70625

Parent Item: D900-619-011

Parent Item Name: Bearpaw

Start Date: 6/10/2011 **Required Date:** 6/22/2011

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP .C□04.02.17□Blank size changed on Step 3□KJ/JLM□
IPP Rev:D Was k10010 07-01-03 JLM
IPP Rev:E New Manufacturing Method 08-11-04 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-15A Bolt		Purchased	No			110	Each	315.0000	8	16	m119449. SP. 16x,		
AN960JD416 Washer	NAS1149D0463J	Purchased	No			110	Each	0.0000	8	16	m119697 SP 16x		
D2182B Rubber Cushion		Manufactured	No			110	f	251.9552	2	4	B73932 SP.		
D2274 Radius Block		Manufactured	No			110	Each	519.0000	8	16	B72121 16x SP 11-11-30		

AN4-15A locations:

Location		Loc Qty	Loc Code
ST357		200	
	117423	200	
ST358		115	
	117854	15	
	117872	100	

D2182B locations:

Location		Loc Qty	Loc Code
ST410		251.95517	
	66063	251.95517	

(D2182B060) cut 4 at 6.00" as per dwg per kit

D2274 locations:

Location		Loc Qty	Loc Code
ST010		519	
	68942	219	
	69736	200	
	69773	100	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** _____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID: 70625

Parent Item: D900-619-011

Parent Item Name: Bearpaw

Start Date: 6/10/2011 **Required Date:** 6/22/2011
Start Qty: 2.00 **Required Qty:** 2.00

Item	Type			Unit	Qty		Picked
D2421 Bearpaw, 900	Manufactured	No	110	Each	1.0000	2	4 B706026.SP 4X

Location	Loc Qty	Loc Code
ST496	1	
60444	1	

Item	Type			Unit	Qty		Picked
D2519 Clamp	Manufactured	No	110	Each	41.0000	4	8 SP

Location	Loc Qty	Loc Code
ST462	41	
65118	41	8X

Item	Type			Unit	Qty		Picked
D2529 Washer	Manufactured	No	110	Each	315.0000	8	16 B71161 SP

Location	Loc Qty	Loc Code
ST016	315	
66953	315	

Item	Type			Unit	Qty		Picked
MS21042L4 Nut	Purchased	No	110	Each	5,203.000	8	16 M119017 SP 11-1130

Location	Loc Qty	Loc Code
ST300	5203	
117441	2903	
117601	800	
117885	1500	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 11:04:47 AM

Work Order ID: 70625

Parent Item: D900-619-011

Parent Item Name: Bearpaw

Start Date: 6/10/2011 **Required Date:** 6/22/2011

Start Qty: 2.00 **Required Qty:** 2.00

QS100-M24S Purchased No 110 Each 27.0000 4 8 SP 11-11-30.

Clamp

Location	Loc Qty	Loc Code
ST449	27	
116513	2	
117291	25	

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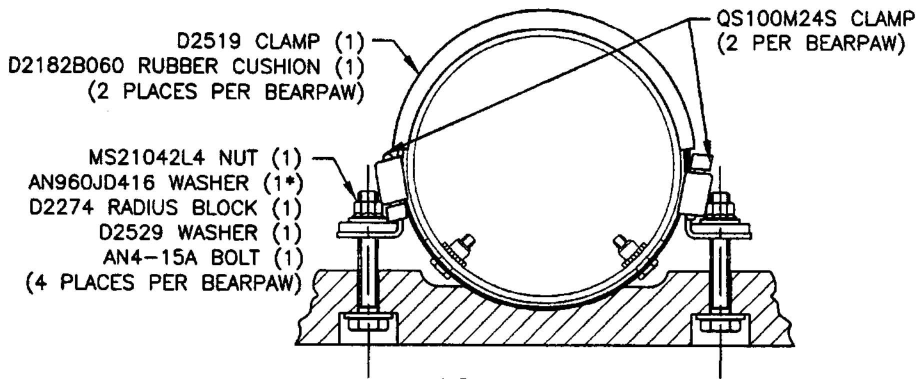
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



*** See note 6**

Figure 32-2: Bearpaw Installation (section view)

6. Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4-15A bolts with longer or shorter AN4 bolts, if required.
7. Lower the aircraft

32.2 BEARPAW REMOVAL

1. Jack up the aircraft.
2. Loosen the clamp bolts and remove the bearpaws and clamps. Ensure the skidtubes are serviceable.
3. Lower the aircraft.

32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D900-619-011 Bearpaw Installation	13.8 lb 6.3 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	233.3 in 5.93 m	3220 in-lb 37.4 m-kg

32.4 PARTS LIST

Qty	Part Number	Description
X	**D900-619-011**	**BEARPAW INSTALLATION**
4	D2182B060	RUBBER CUSHION
8	D2274	RADIUS BLOCK
2	D2421	BEARPAW
4	D2519	CLAMP
8	D2529	WASHER
8	AN4-15A	BOLT
8	AN960JD416	WASHER
8	MS21042L4	NUT (OR MS21042-4)
4	QS100M24S	CLAMP